

Work Order ID 55708

January 28, 2010 10:42:31 AM



Page 1

Item ID: D3943-053

Accept



Setup Start



Revision ID:

Stop



Item Name: Chain Assembly

Start Date: 1/29/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/2010 Req'd Qty: 6.00

Customer:

Reference:



Run Start



Approvals: Process Plan: *umf*

Date: 10-1-28

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3943

B

100

Weld per dwg A/R Steel rod Batch: *m7326*

0.00



Large Fab

Memo

0.00

Large Fab

ASSEMBLE WITH CHAIN BEFORE WELDING

EL

10-2-10



110

QC9- Inspect visual per QS1004- Fusion Welds

0.00

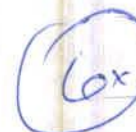


QC

Memo

0.00

Quality Control



BE 10/02/11

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

3) 8 10/02/11



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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

M113544

0.00

21 10/03/09

(X6) 0

Spray Painting

1- MASK CHAIN FROM THIS POINT ON PRIOR TO PAINTING AS PER DWG

10.03.09

2- SPRAY PAINT YELLOW AS PER DWG
A/R BATCH: _____

Start time 3:10pm

First time 376°/ =

air temp 3:40pm

140



QC

Quality Control

QC 3- Inspect Spray Paint

0.00

Memo

BR 10-3-9

(6) 0

150



Packaging

Packaging

Identify as per dwg & Stock Location: w/o

0.00

Memo

55706

0.00

EL 10-3-15 (X6)

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Item ID: D3943-053

Accept



Revision ID:

Setup Start



Item Name: Chain Assembly

Stop



Start Date: 1/29/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/16

R/10-3-14
(6)

Picklist Print

January 28, 2010 10:42:31 AM

Page 1

Work Order ID: 55708

Parent Item: D3943-053

Parent Item Name: Chain Assembly


Comments:

Start Date: 1/29/2010

Required Date: 2/22/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3954-5  Chain Lug		Manufactured	No			100	Each	1.0000	6.0000			

EL 10-2-10

55712 X6

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST139C	1	
52098	1	

D3954-9

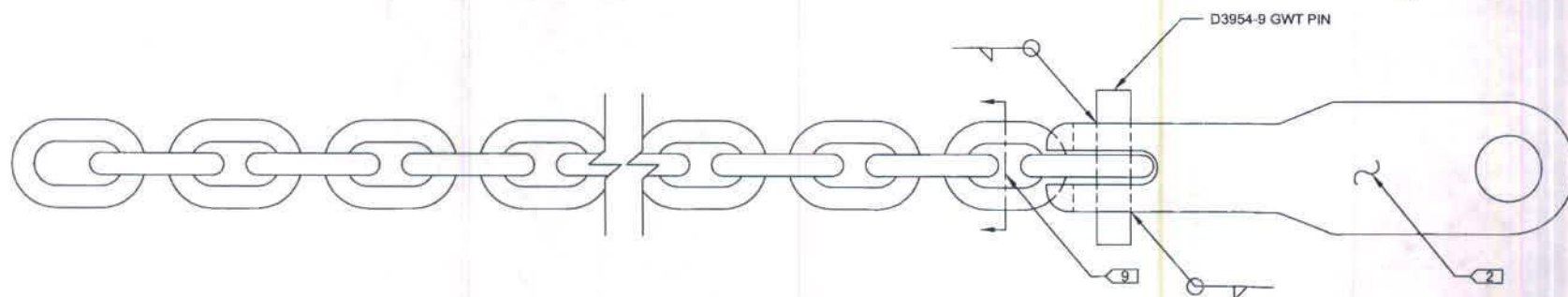
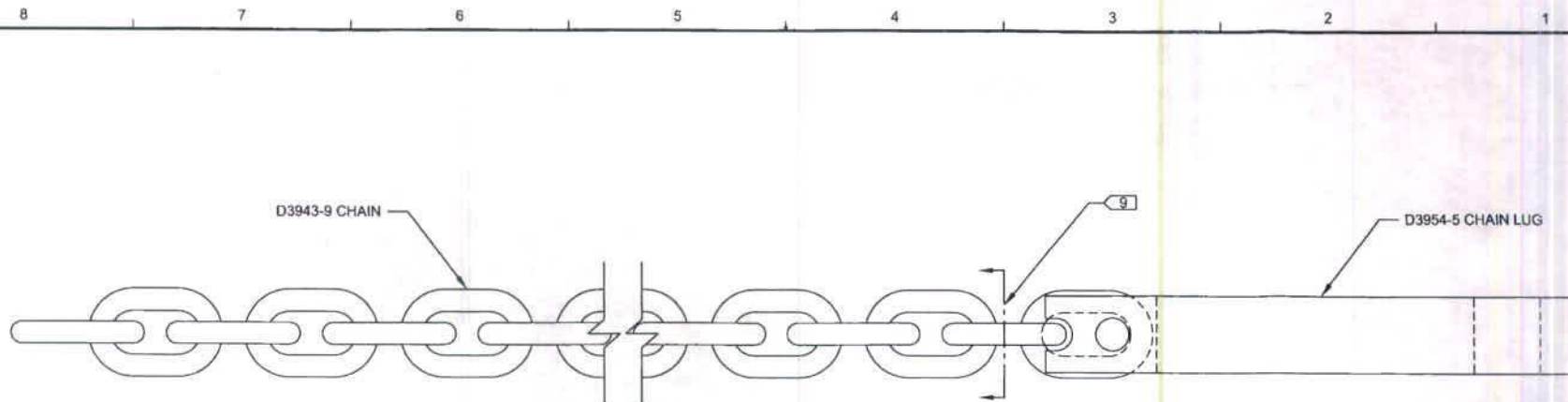
GWT Chain Pin

Manufactured	No					100	Each	25.0000	6.0000			
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EL 10-2-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	25	
52193	1	
52991	24	

6



D3943-053 CHAIN ASSEMBLY

NOTES -053:

- 1) MATERIAL: N/A
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER QSI 004
- 9) MASK CHAIN FROM THIS POINT ON PRIOR TO POWDER COATING



DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3943	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	09.10.15	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DEO ATTACHED
RELEASED
2009-10-19
MP

#55708

DRAWING NO. D3943	TITLE GROSS WEIGHT TOW CRANK ASSY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3943-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.	N/A		
DATE 09.10.30	DATE 09.10.30	DATE 09/11/04	DATE 09/10/30	DATE			

SHEET 1 PARTS LIST MODIFY ITEM 43 AS SHOWN:

#55708

IS:

43	3			HX-16	SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG	HASKINS
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WAS:

43	3			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG	HASKINS
----	---	--	--	-------	-------------------------------------------	---------

RELEASED
2009-11-18

REASON: DRAFTING ERROR

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